

5/42

DART AEROSPACE LTD	Work Order:	24337
Description: Seal	Part Number:	D3117-3
04.11.29		
Dwg: D3117 Rev. A B C	Qty:	500
05.10.04		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	<i>[Signature]</i>	05.09.26	500
2	PG	Issue P/O: <u>2008732</u> D3117-3 Seal as per Dwg D3117 Possible Supplier: VIP Rubber Replace Premier P/N: B45-43000-03 Material release note required	<i>[Signature]</i>	05/10/05	500
3	RG	Receive and inspect for transit damage Ensure material release note is attached	<i>[Signature]</i>	05/12/13	518
4	QC6	Inspect dimensions as per Dwg D3117 and certification attached.	<i>[Signature]</i>	05-12-13	518
5	PG	Issue P/O: _____ Cut Qty 3 sample 12" long of D3117-3 Send for testing to meet vertical burn test per F.A.R. 25.853 Possible testing site: Bodycote Materials Testing Canada Inc. Test report is required	<i>[Signature]</i> N/A see 2H2hed e-mail		
6	RG	Attach test report to W/O			
7	ST	Identify and Stock LOC: 345	<i>[Signature]</i>	05/12/14	518
8	AC	Cost / part	<i>[Signature]</i>	05-12-15	518
9	DC	Close W/O Inspect Level 21	<i>[Signature]</i>	05/12/15	518

Rev	Date	Change	Revised By	Approved
A	03.01.22	New issue	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

RELEASED
03.01.23 *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

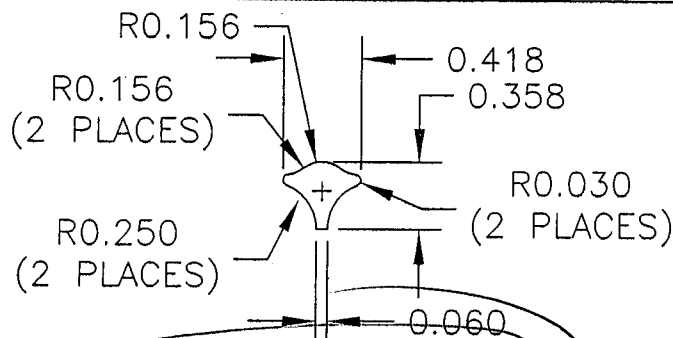
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 05/12/15

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

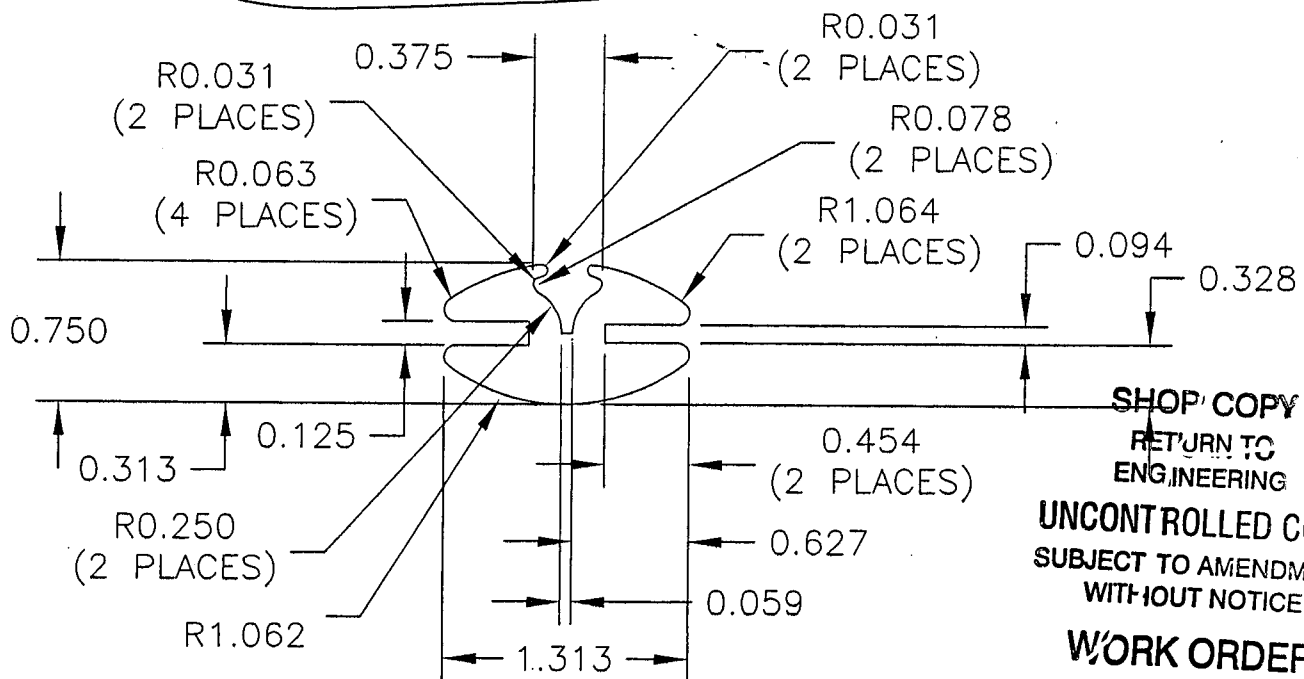


DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3117	REV. C SHEET 1 OF 1
DATE 05.10.03		TITLE SEAL	SCALE 1:1
A	02.04.15	NEW ISSUE	
B	04.10.18	UPDATES NOTES	
C	05.10.03	50 DUROMETER WAS 60 DUROMETER	



D3117-3-XXXX SEAL FILLER
REPLACES PREMIER P/N B45-43000-03

RELEASED
05.10.03 *[Signature]*



D3117-1-XXXX SEAL RETAINER
REPLACES PREMIER P/N B45-43000-01

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 24337

NOTES

- 1) -XXXX = LENGTH IN INCHES (EG. 10" LONG = -0100, 87.5" LONG = -0875)
- 2) MATERIAL: BLACK RUBBER 50 DUROMETER (HARDNESS) NEOPRENE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 26, 2005
10:48 am

Work Order No : 0024337
Project Name : D3117-3
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D3117-3
Description : Seal Filler
Manufactured : Yes
Amount Req'd : 500
Amount Done : 0
Start Date : 09-26-05
Est Finish Date : 10-12-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Blue
order

EXTRUDED AND MOLDED RUBBER • EXTRUDED PL
540 S. CYPRESS STREET, LA HABRA, CA 90631
(310) 905-3456 • (800) 722-4VIP
Fax: (310) 905-3460

**CERTIFICATION
OF COMPLIANCE**

ITEM NO

RE-7107-1897-0156

CUSTOMER PO

2008732

DATE

10-17-05

SHIPPER NO.

48151

S
H
I
P
T
O

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY ONTARIO, CANADA
K6A1K7 613-632-9577

#5263

PART NO/DESCRIPTION

QUANTITY
ORDERED

P/N D3117-1 REV C RETAINER

500 FT

P/N D3117-3 REV C FILLER

500 FT

(DWG. #D3117 REV C)

CURE DATE

4005

SPECIFICATION

50/NEOPRENE FORMULATED TO MEET THE FLAME
RESISTANCE TEST OF FAR 25.853a

By

Edward V. ...

President

VIP RUBBER COMPANY

J

DATE SHIPPED

12/1/05

QTY SHIPPED

513'

513'

Linda Lacelle

From: David Shepherd [davids@dartaero.com]
Sent: Wednesday, December 14, 2005 11:45 AM
To: Linda Lacelle
Cc: Jean-Luc Menard
Subject: Re: D3117

For some reason, Premier had put a note on their drawing to test every batch of this stuff. So when we created our drawing, we did the same. However, we now have our own STC for this product and at Rev. C, the note about testing every batch has been removed. Therefore, you DON'T need to send to Bodycote for burn testing. JL should remove this requirement if it is still on the IPP.

David

----- Original Message -----

From: "Linda Lacelle" <llacelle@dartaero.com>
To: "*David Shepherd (E-mail)" <davids@dartaero.com>; "*Roberto Fuentes (E-mail)" <robertof@dartaero.com>
Sent: Wednesday, December 14, 2005 5:26 AM
Subject: D3117

>
> Hi,
> The w/o's for D3117-1 / -3 are asking to issue a P.O to Bodycote fo a burn
> test ??? Isn't this done just once? Should this still be on the IPP ?
> LL
>
>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries